

Work Order ID 52896

October 19, 2009 10:38:44 AM

Page 1

Item ID: D3173-041
Revision ID: B
Item Name: Beam Assembly

Accept

Start Date: 10/19/09 Start Qty: 6.00
Required Date: 10/27/09 Req'd Qty: 6.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: 09-10-14 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3173	Rev B								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 56" long 1 Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1

M.A
09/10/25

2

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1

M.A
09/10/25

2

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

M.A
09/10/25

2

0

20356

Work Order ID 52896

October 19, 2009 10:38:44 AM

Page 2

Item ID: D3173-041

Accept

Revision ID: B

Item Name: Beam Assembly

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 6.00

Required Date: 10/27/09 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start




Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	mL 09/10/26			2	0		
140  Small Fab Small Fab	Small Fab Memo 1-Drill Ø0.316" holes as per Dwg D3173 112-C'sink holes as per Dwg D3173 113-deburr	0.00 0.00				EFS 09/10/27 (2)			
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) 5 02/10/29			(2)	9		

Work Order ID 52896

October 19, 2009 10:38:44 AM

Page 3

Item ID: D3173-041
Revision ID: B
Item Name: Beam Assembly

Accept

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 6.00
Required Date: 10/27/09 Req'd Qty: 6.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160 Chemical Conversion Coat per QSI005 4.1 0.00

HandFinish

Memo

0.00

Hand Finishing

MO 09/11/02 X2

170 ~~QC3-Inspect part completeness to step on W/O~~ 0.00

QC

Memo

0.00

Quality Control

BR 09-11-2

(2)

180 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

Powdercoat

Memo

0.00

Powder Coating

Ensure Nut Plate thread is covered. ☐ START TIME:
1:15 ☐ OVEN TEMPERATURE: 320° ☐ FINISH
TIME: 1:45

BR 09-11-2

(2)

Work Order ID 52896

October 19, 2009 10:38:44 AM

Page 4

Item ID: D3173-041

Accept

Revision ID: B

Item Name: Beam Assembly

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 6.00

Required Date: 10/27/09 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

200

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble per Dwg D3173. Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

210

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

27 801/12/24

(x2)

f

8/30/11/24

(2)

27 801/12/24

(x2)

f

Work Order ID 52896

October 19, 2009 10:38:44 AM



Page 5

Item ID: D3173-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Beam Assembly

Start Date: 10/19/09 Start Qty: 6.00



Cust Item ID:

Required Date: 10/27/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

Identify as per dwg & Stock Location: 516

0.00



Packaging

Memo

0.00

Packaging

09/11/25 (2)

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25

Pl 09/11-25

Picklist Print

October 19, 2009 10:38:53 AM

Page 1
5

Work Order ID: 52896

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly


Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 6.00


Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			100	Each	1,118.000	12.0000			
												
Nut												

EP 09/11/03

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1118	
110382	10	
111127	4	
111636	104	
112314	1000	

4

D3178-041RevA	Manufactured	No				170	Each	18.0000	12.0000			
												
Nut Plate												

EP 09/11/03

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
24895	10	
25298	8	

4

Picklist Print

October 19, 2009 10:38:53 AM

Page 2

Work Order ID: 52896

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly

Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6TR4.0X2.0W1 25		Purchased	No			170	f	15.9600	29.6053			



6061-T6 Rect Tube 4.0 x 2.0 x .125w



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	15.96	
109025	0.31	
→ 109088	10.16	
14394	4.66	
19265	0.83	

AN3-5A Purchased No

200 Each 2,259.000 48.0000



Bolt



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2259	
100188	188	
105057	2071	

9.81
Y.A 09/10/26
E/S 09/11/03 24
416

October 19, 2009 10:38:53 AM

Shop Packet Print

Page 2

Picklist Print

October 19, 2009 10:38:53 AM

Page 3

Work Order ID: 52896

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly


Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-23A  Bolt		Purchased	No			200	Each	25.0000	12.0000			

EP 10/11/09

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

25

19278

25

AN960JD10

Purchased

No

200

Each

1,920.000

48.0000

Washer

4
EP 10/11/09 24

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1920

105442

95

109059

2

109840

23

110985

202

111279

5

111668

64

112314

1000

112369

529

8 16

October 19, 2009 10:38:53 AM

Shop Packet Print

Page 3

October 19, 2009 10:38:53 AM

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly

Comments:**Start Date:** 10/19/09

Required Date: 10/27/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			200	Each	1,688.000	24.0000			

AN960JD516



Washer

2809/11/03

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1688	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	68	
112314	500	
112794	274	
112828	500	

Picklist Print

October 19, 2009 10:38:53 AM

Page 5

Work Order ID: 52896

Parent Item: D3173-041RevB

Parent Item Name: Beam Assembly



Comments:

Start Date: 10/19/09

Required Date: 10/27/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3175-041RevA		Manufactured	No			200	Each	6.0000	12.0000			
												
Mounting Lug												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

25025

1

41678

5

MS20601-AD4W4

Purchased

No

200

Each

47.0000

48.0000



Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47

19278

47

Ep 09/11/03 24
b534582

E

Ep 09/11/03

16

October 19, 2009 10:38:53 AM

Shop Packet Print

Page 5



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3173	REV. B SHEET 1 OF 3
DATE 03.01.07		TITLE BEAM ASSEMBLY	SCALE NTS
A	02.12.03	NEW ISSUE	
B	03.01.07	REMOVE PIP PINS	

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3173-041	BEAM ASSEMBLY
1	D3173-1	BEAM
2	D3175-041	MOUNTING LUG
2	D3178-041	NUT PLATE
8	AN960JD10	WASHER
4	AN960JD516	WASHER
2	MS21042L5	NUT
8	MS20601AD4W4	RIVET
8	AN3-5A	BOLT
2	AN5-23A	BOLT

NOTES

D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

1103 01.20 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52896

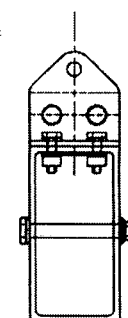
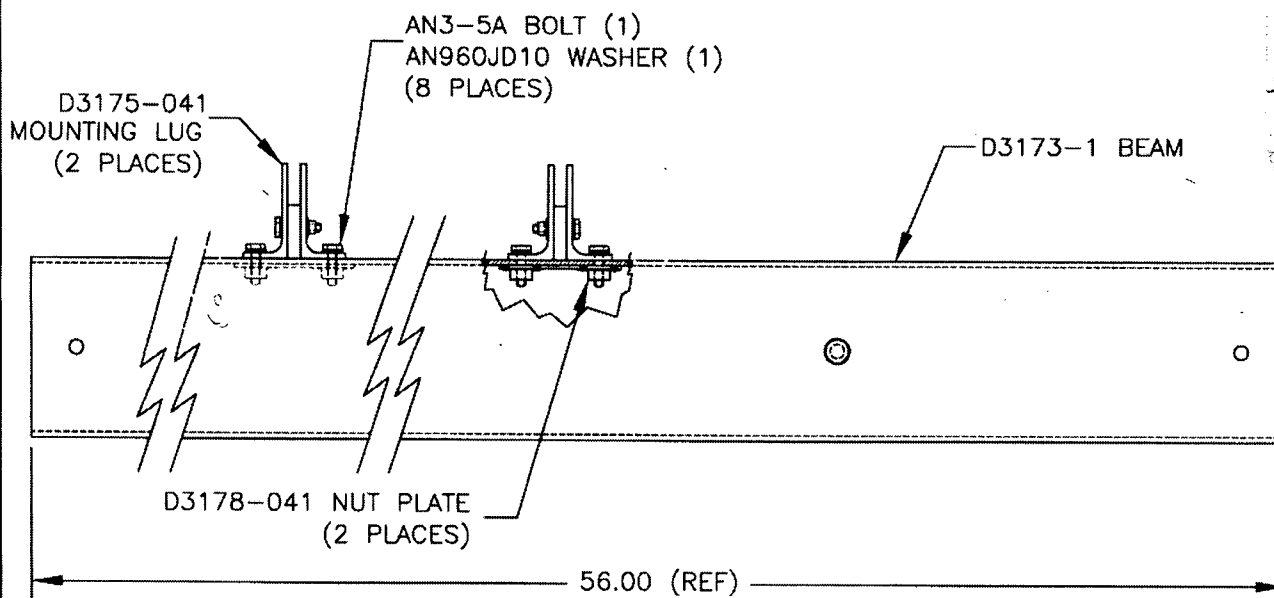
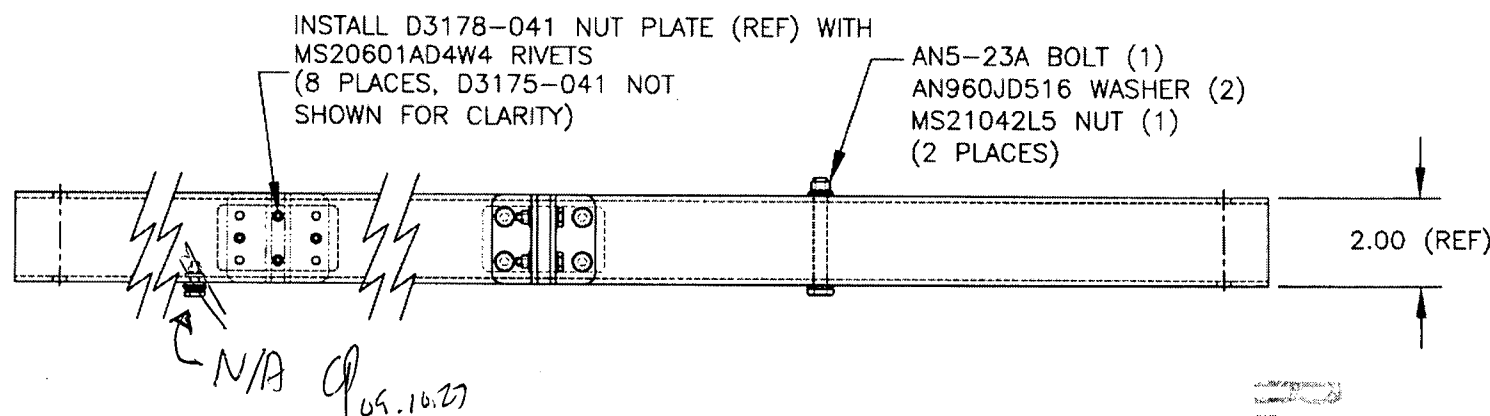
[Signature] 09-10-10

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D3173	SHEET 2 OF 3
03.01.07		TITLE	SCALE
		BEAM ASSEMBLY	1:4



D3173-041 BEAM ASSEMBLY

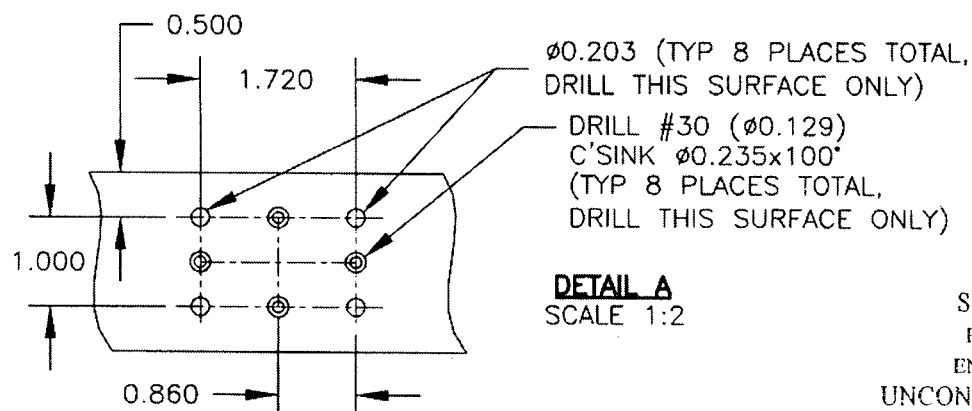
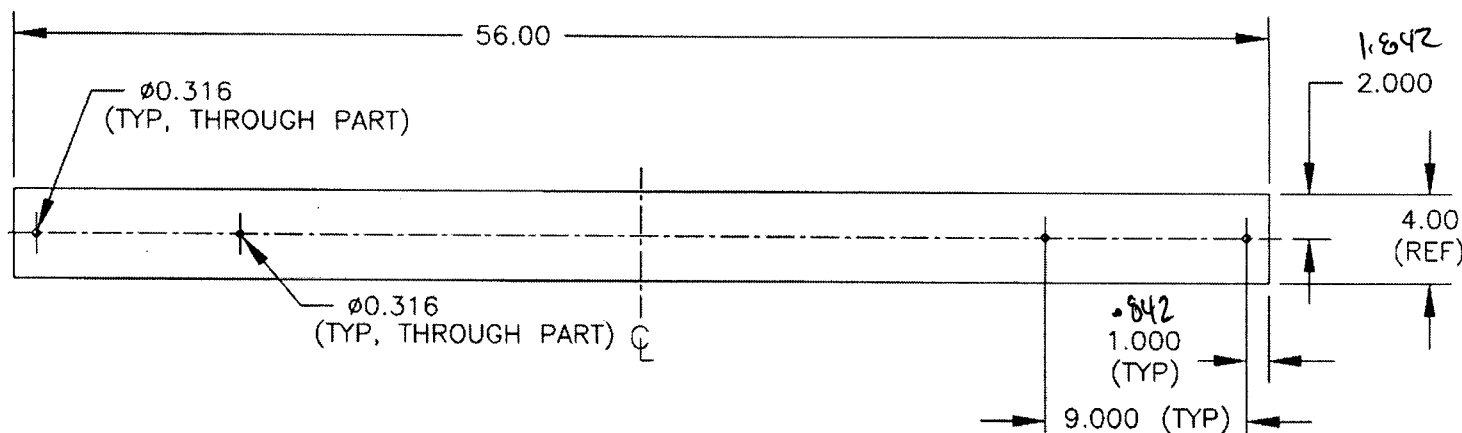
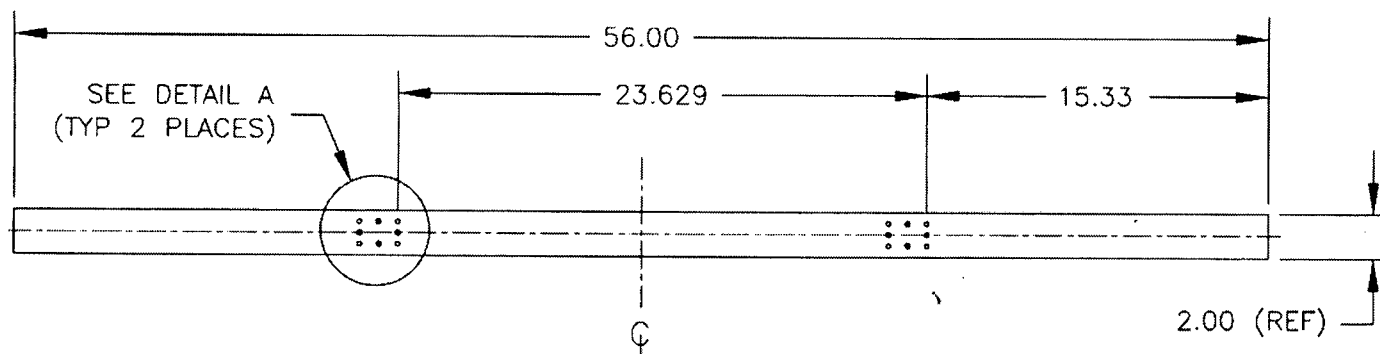
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52896

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D3173	SHEET 3 OF 3
03.01.07		TITLE	SCALE
		BEAM ASSEMBLY	1:8

D3173-1 BEAM



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 52894

D3173-01
ANS-30A